

Date: Friday, 5/25/2007 8:36:41 AM
 User: Kim Johnston

Process Sheet *SPLIT*

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	ARM	POSITIVE RECALL
Job Number	32645	Part Number	D3560042	EFFECTIVE <u>07.06.05</u> AUTH <i>JP</i>
Estimate Number	12882	Drawing Number	D3560 REV.B	RELEASED <u>07.06.16</u> DATE <i>JP</i>
P.O. Number	<i>N/A</i>	Project Number	N/A	
This Issue	5/25/2007	Drawing Revision	B	
Prsht Rev.	NC	Material	<i>N/A</i>	
First Issue	<i>N/A</i>	Due Date	6/5/2007	Qty: 30 Um: Each
Previous Run	<i>N/A</i>			
Written By				
Checked & Approved By	<i>JF-BG 05.25</i>			
Comment	Est Rev:A	New Issue	07.05.24	EC

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B0500X05000	6061-T6 Bar .50" x 5.0"	
		Comment: Qty.: 1.4648 f(s)/Unit Total : 43.9425 f(s) 6061-T6 Bar 0.50" x 5.0" <i>M104598 X 20 pcs</i> Batch: <i>17625X10</i>	<i>JF-BG 07.06.01</i>
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut blanks 16.750" long	<i>JF-BG 07.06.01</i>
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1	
		1- Mill as per Folio FA694 Rev: <i>A</i> & Dwg D3560 Rev: <i>B</i>	
		2-C'sink 0.196" hole on manual mill as per dwg D3560 <i>BAO 07/06/28</i>	
		3-Deburr per dwg D3560 <i>JF-BG 07.06.01</i>	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>JF-BG BA 07.06.01</i>	
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK <i>JF-BG 07/06/12 (19) Split</i>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07.06.06	11	NO POWDER COAT. CHEM. CONV. COAT ONLY. REF ATTACHED DS EMAIL				QP 07.06.06 pw QSI 042	J 07.06.07
07.06.18	2A	D2808 Board <u>1x 28600</u> / <u>4x 32752</u> Put Board	PE	07.06.27	6	U 07.08.16	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA  Date: 07/07/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.06.08	3	Qty(1) C-Bore Ø0.510 INSTEAD OF Ø0.507	QP 07.06.08 pw QSI 042	SCRAP/ REPLACE	J.F. 07/06/27	07/06/27	QP 07.06.08 pw QSI 042	J 07.06.27

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: ARM
Job Number: 32645		Part Number: D3560042
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	D35921	PLATE
Comment: Qty.: 1.0000 Each(s)/Unit Total : 30.0000 Each(s) PLATE 32645		ST. 07.06.26
7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1		
1-Weld assembly as per dwg D3560		Weld Rod B 104305
8.0	QC5	INSPECT WORK TO CURRENT STEP
		<i>07.06.27 C</i>
Comment: INSPECT WORK TO CURRENT STEP		
9.0	QC9	VISUAL WELDING INSPECTION
Comment: VISUAL WELDING INSPECTION PD 07.06.28 ⑥		
10.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 AM 07.06.28		
11.0	POWDER COATING	POWDER COATING
		<i>No POWDER COAT SEE WID CHANGE</i>
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3		
12.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT/ CHEMICAL CONVERSION PE 07.06.28		
13.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: WA ST. 07.06.28		

W/WO:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

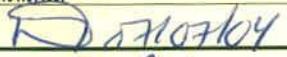
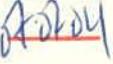
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/07/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:36:41 AM
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Job Number: 32645		Part Number: D3560042
Job Number:		
Seq. #:	Machine Or Operation:	Description :
14.0	QC21	FINAL INSPECTION/W/O RELEASE
		
Comment: FINAL INSPECTION/W/O RELEASE		 
Job Completion		
<p style="color: red;">POSITIVE RECALL</p> <p>EFFECTIVE _____ AUTH _____ RELEASED _____ DATE </p> 		

W/WO:

WORK ORDER CHANGES

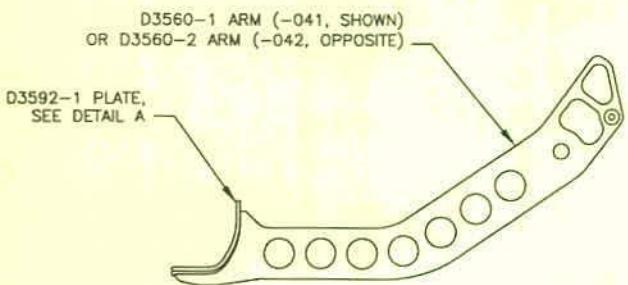
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

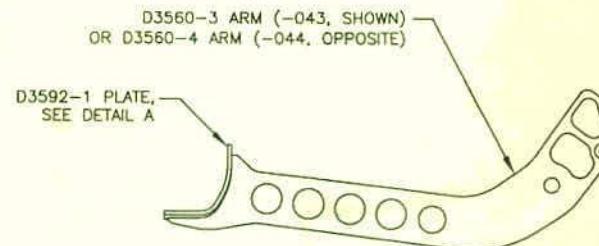
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

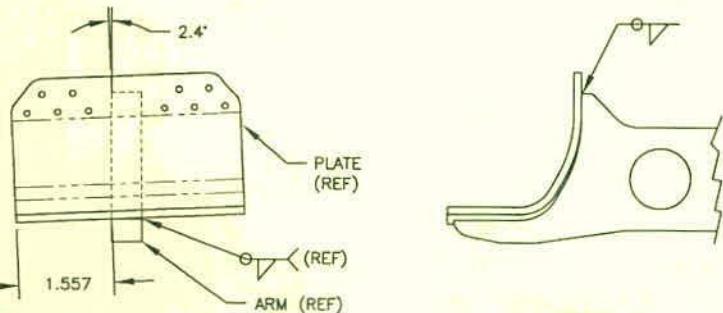
NOTE: Date & initial all entries



D3560-041 ARM WELDMENT (SHOWN),
D3560-042 ARM WELDMENT (OPPOSITE)



D3560-043 ARM WELDMENT (SHOWN),
D3560-044 ARM WELDMENT (OPPOSITE)



GENERAL NOTES

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 004 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED

07.05.07 *[Signature]*

B	07.01.15	REDESIGN AS WELDMENT, ADD POCKETS
A	06.09.25	NEW ISSUE
DESIGN	97	DRAWN BY
CHECKED	<i>[Signature]</i>	APPROVED
DATE		DRAWING NO.
07.01.15		03560
		TITLE
		ARM WELDMENT

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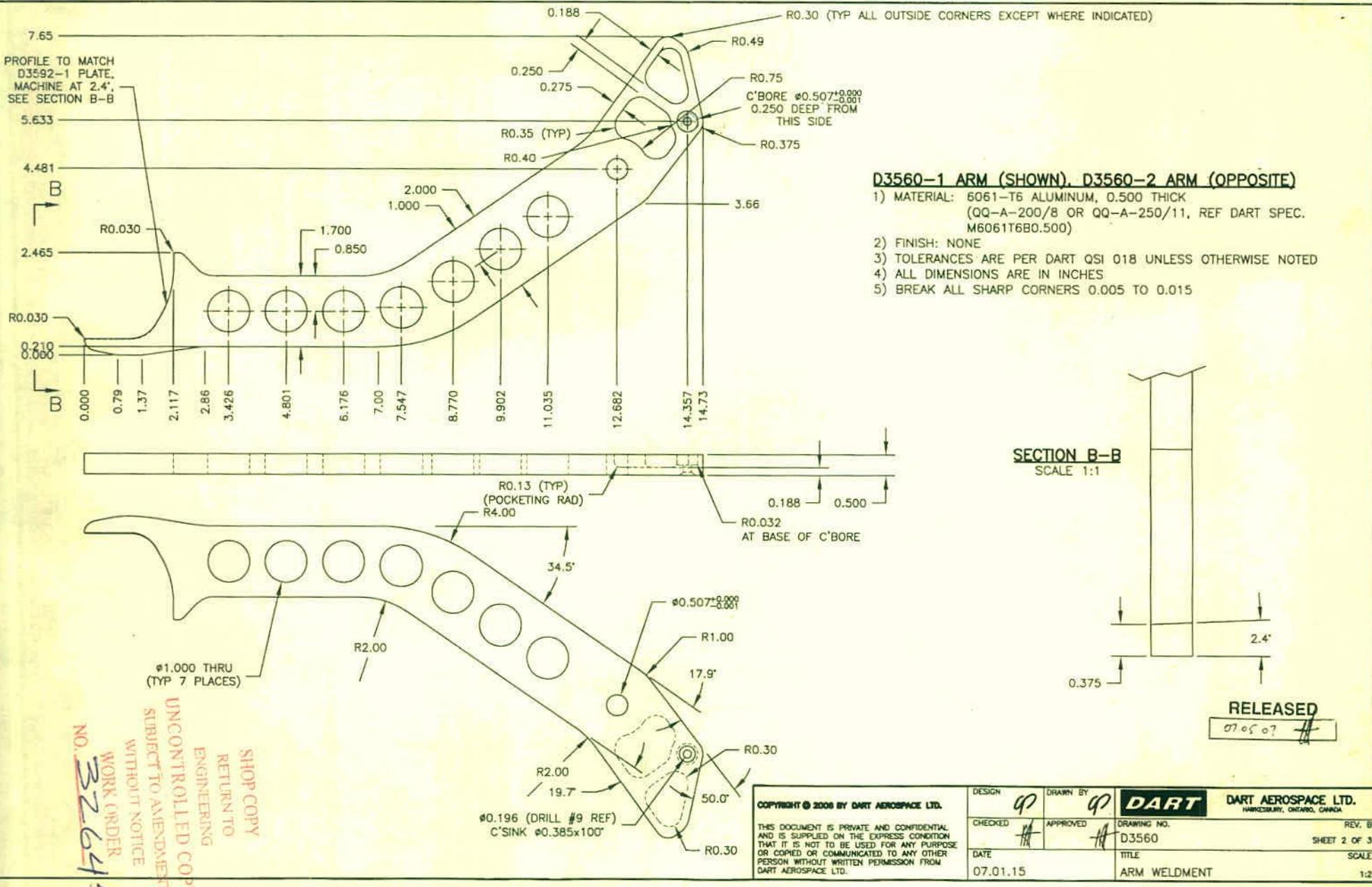
DART AEROSPACE LTD.
HAMILTON, ONTARIO, CANADA

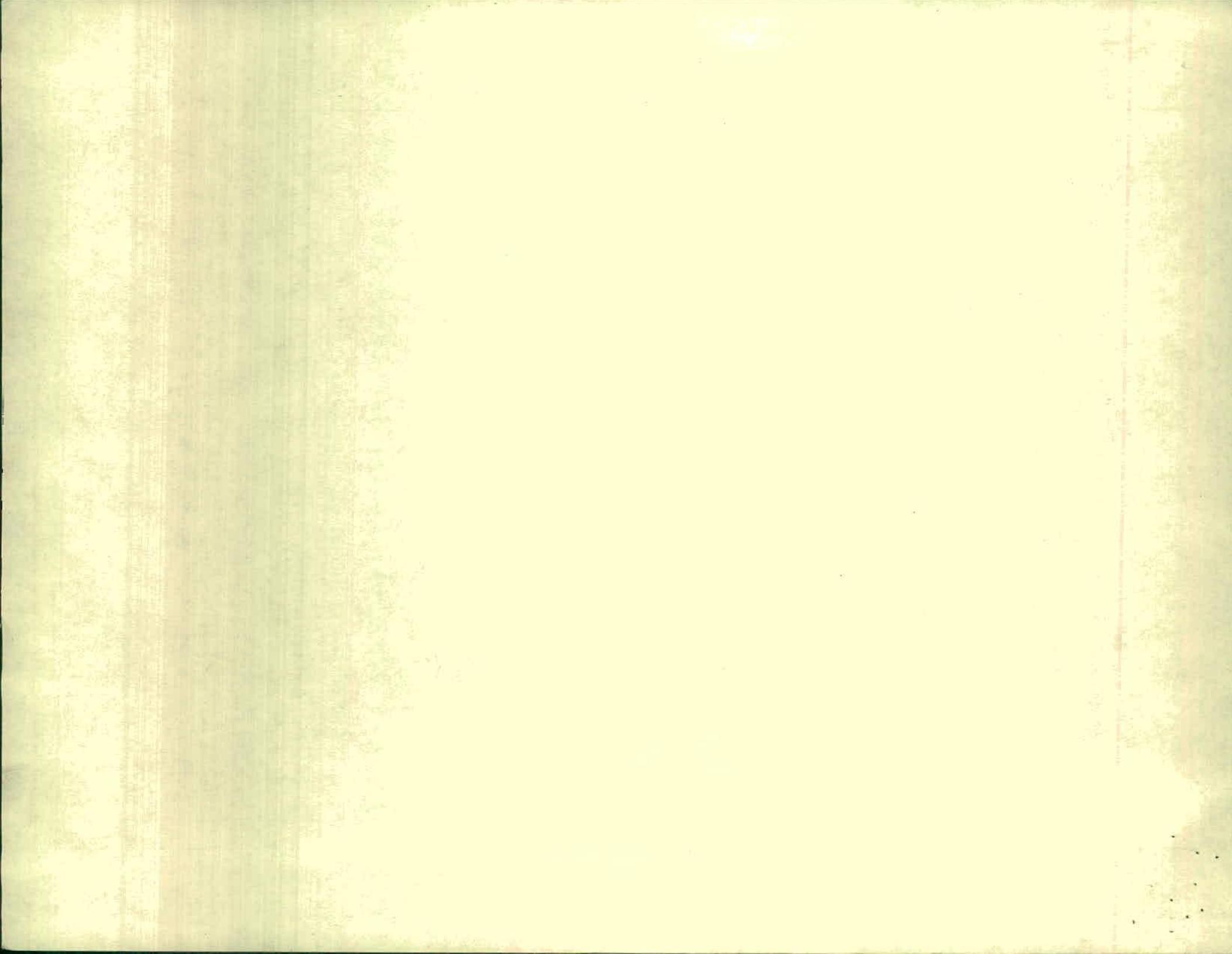
REV. B
SHEET 1 OF 3
SCALE
1:14

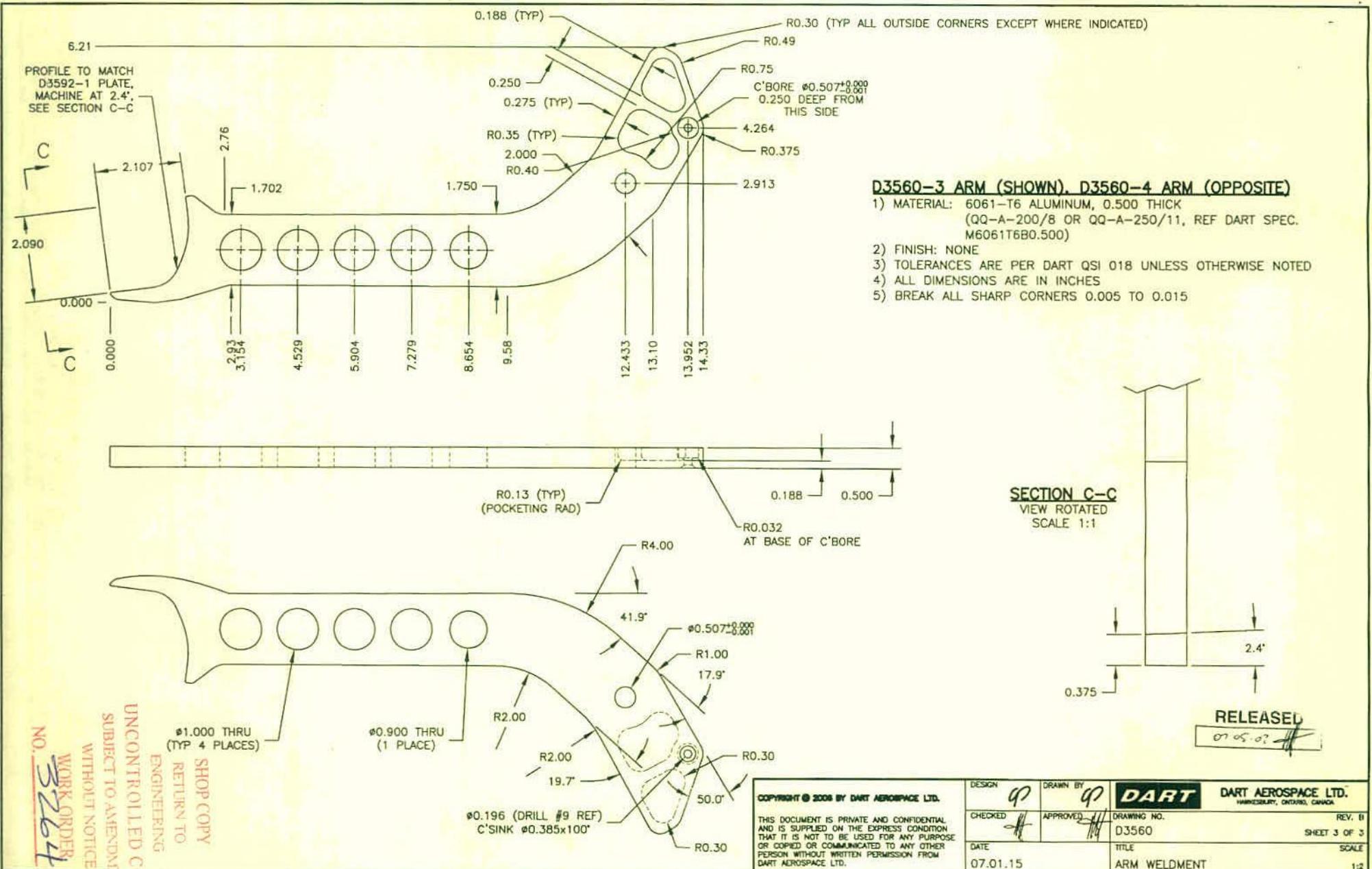
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
32645

SHOP COPY
ENGINEERING
RETURN TO









NO. 3264
WORK ORDER

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SUBJECT TO AMENDMENT
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DART AEROSPACE LTD

Work Order: 52645

Description: CrossTube Assembly

ATM

Part Number: 3560-2

Inspection Dwg: 73560

Rev: B

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

 First Article Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	14.73	14.73	—			
	.507	.507	—			
	.250	.250	—			
	.188	.188	—			
	.250	.250	—			
	.275	.275	—			
	2.465	2.465	—			
	12.682	12.682	—			
	14.73	14.73	—			
	4.481	4.481	—			
	5.633	5.633	—			
	.188	.188	—			
	.432	.432	—			
	.502	.502	—			
SIDE B	.507	.507	—			
	.196	.199	—			
	385 x 10.00	385	✓			
	1.000	1.000	—			
	2.000	2.000	—			
	1.000	1.000	—			
	.375	.375	—			
	12.1304	12.13	—			
	.850	.850	—			

Measured by: JLAudited by: JLPrototype Approval: JL N/A

Date: 07-06-01

Date: 07/06/01

Date: 07/06/01

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

1
2
3

Chris Provencal

From: David Shepherd [dshepherd@dartaero.com]
Sent: June 5, 2007 5:18 PM
To: 'Chris Provencal'
Subject: RE: D3562-041/-042

As we have discussed previously, this is acceptable as long as the Magnabond doesn't break down.

David

From: Chris Provencal [mailto:cprovencal@dartaero.com]
Sent: Tuesday, June 05, 2007 11:00 AM
To: David Shepherd (David Shepherd)
Subject: D3562-041/-042

David,

For the D3562-041/-042 step weldment, as discussed. They want to switch from Sikaflex to Magnabond, and powder coat after final assembly.

As part of this change, the D3560-XX arms won't be powder coated, and the D2808 Bushing won't be assembled until after final assembly of the step weldment.

Since this is the first time trying this, we will ensure that the steps are checked after powdercoating in case the Magnabond doesn't anything unexpected (eg. bubbling). If we see anything suspect, we will assemble them the old way.

Is this acceptable.

-Chris

No virus found in this incoming message.

Checked by AVG Free Edition.

Version: 7.5.472 / Virus Database: 269.8.9/834 - Release Date: 6/5/2007 2:38 PM

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